



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PRELIMINARY ISSUE

650.7810
Job Sheet 211175



Part No: 650.7810

Job Qty: 3 pcs

Part Name: Pull Rod



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/8/20

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 7/17/20

Description:

Type: Stock

Note: DWG 650.7810 REV.PA1 IPP REV A 20.07.02 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

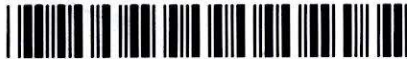
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	DAS Sign-off
					Setup Hrs	Run Hrs		
100	SL-154 - 1	3 pcs	7/9/20	7/9/20	0.50	0.75	SL-154 - 1	33 20/07/20 9-89
110	QC 2	3 pcs	7/9/20	7/9/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	DAS
							QC 2 - 33	33 20/07/20 9-89
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	



Container No: S289225



Part: 650.7810

Job No: 211175

Serial No/Batch: S289225

Revision: REV.PA1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/20/20

Plex 7/8/20 11:07 AM Dart.Renwick.Jennifer

7/8/2020

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

				QC 2 - 5		
				QC 2 - 71		
				QC 2 - 73		
				QC 2 - 69		
				QC 2 - 76		
				QC 2 - 86		
				QC 2 - 83		
112	HAAS 5 Axis - B4B	3 pcs	7/10/20	0.50 0.75	HAAS - 1 - 5 - B4B	DAS 33 20/08/21
					HAAS - 2 - 5 - B4B	9-89
114	QC 2	3 pcs	7/10/20	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	DAS
					QC 2 - 33	33 20/08/21
					QC 2 - 35	9-89
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
120	QC 8	3 pcs	7/10/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	

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7/8/2020

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
130	Outsource - 17 - Passivate	3 pcs	7/17/20	GRO002-VC	5 <i>2020-08-25</i>
160	Packaging 2-1 - Receive - B4B	3 pcs	7/17/20	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B <i>11e AUG 31 2020</i>
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
					Packaging 2 - 37 - B4B
165	QC 6	3 pcs	7/17/20	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40

Plex 7/8/20 11:07 AM Dart.Renwick.Jennife

7/8/2020

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

68-6
78
DAS

				QC 6 - 81	SEP 01 2020
				QC 6 - 82	
170 QC 21 - SA	3 pcs	7/17/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	

.Part Op **100** - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** MUST ENSURE THE COMPONENTS ARE
 Descriptions: NEVER DAMAGED**** 1-Machine as per folio FD320 FOLIO REV: AA DWG REV: PA1 2-Debur
110 - QC2- Inspect parts off machine FAI/FAIB
112 - 1-Machine as per folio FD320-H5 FOLIO REV: L DWG REV: _____ 2-Debur
120 - QC8- Inspect parts - second check
130 - -Issue P/O; 46954 PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of
 Conformity is required
160 - Identify as per dwg & Stock
165 - QC6- All purchased or subcontracted products
170 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M303R0.375	303 Round Bar 0.375"	.6930 ft (.231 ea)	100-SL-154 - 1	<u>5243101</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	M303R0.375	1	65	0

Part Specifications
Specifications could not be found.

Plex 7/8/20 11:07 AM Dart.Renwick.Jennifer

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

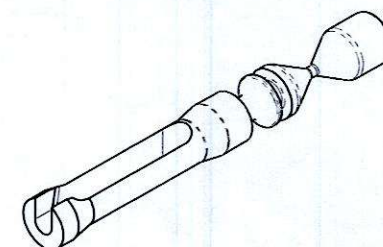
Job: <u>211175</u> Part No. <u>650.7810</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐		
Date : <u>SEP 01 2020</u>	Sequence #:	QTY Affected : <u>3 PCS</u>	MRS (QSI042) DAS 51 9-89 <u>20/09/01</u>	
Description Work Order Deviation DURING INSPECTION IT WAS FOUND THAT DIMENSION (24) .080 +.005 -.000 IS AT .0798, <u>.0796 AND .0794.</u>		Disposition <u>Acceptable (fortesting only)</u>		Completed By DAS 32 9-89 <u>SEP 01 2020</u>
				Lead hand / Supervisor
				QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:				

PROTOTYPE REVISIONS

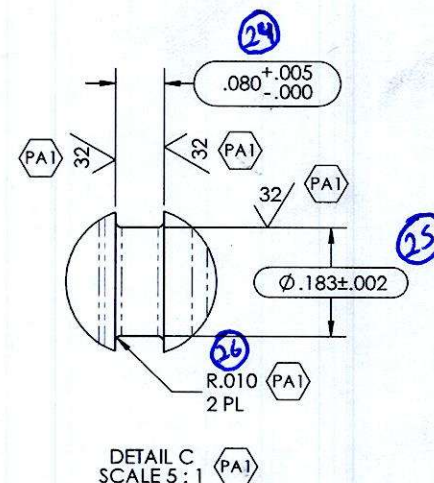
1. MATERIAL: 303 SS IAW AMS-5640 (34)
2. DEBURR AND BREAK ALL SHARP EDGES
3. IDENTIFY IAW MPP-120
4. FINISH 125/ MAXIMUM UNLESS OTHERWISE SPECIFIED
5. PASSIVATED IAW MPP-172, SECTION 6. (35)

ZONE	REV	DESCRIPTION	DATE	APPROVED
B1-1 B2-1 C2-1 C6-1 C7-1	PA1	ADDED R.093 DIMENSION ADDED VIEW B-B ADDED SURFACE ROUGHNESS VALUE ADDED SURFACE ROUGHNESS VALUE ADDED DETAIL C ADDED SURFACE ROUGHNESS VALUES ADDED R.010 2 PL DIMENSION ADDED DETAIL D	06/01/2020	T. CROSS
D2-1				

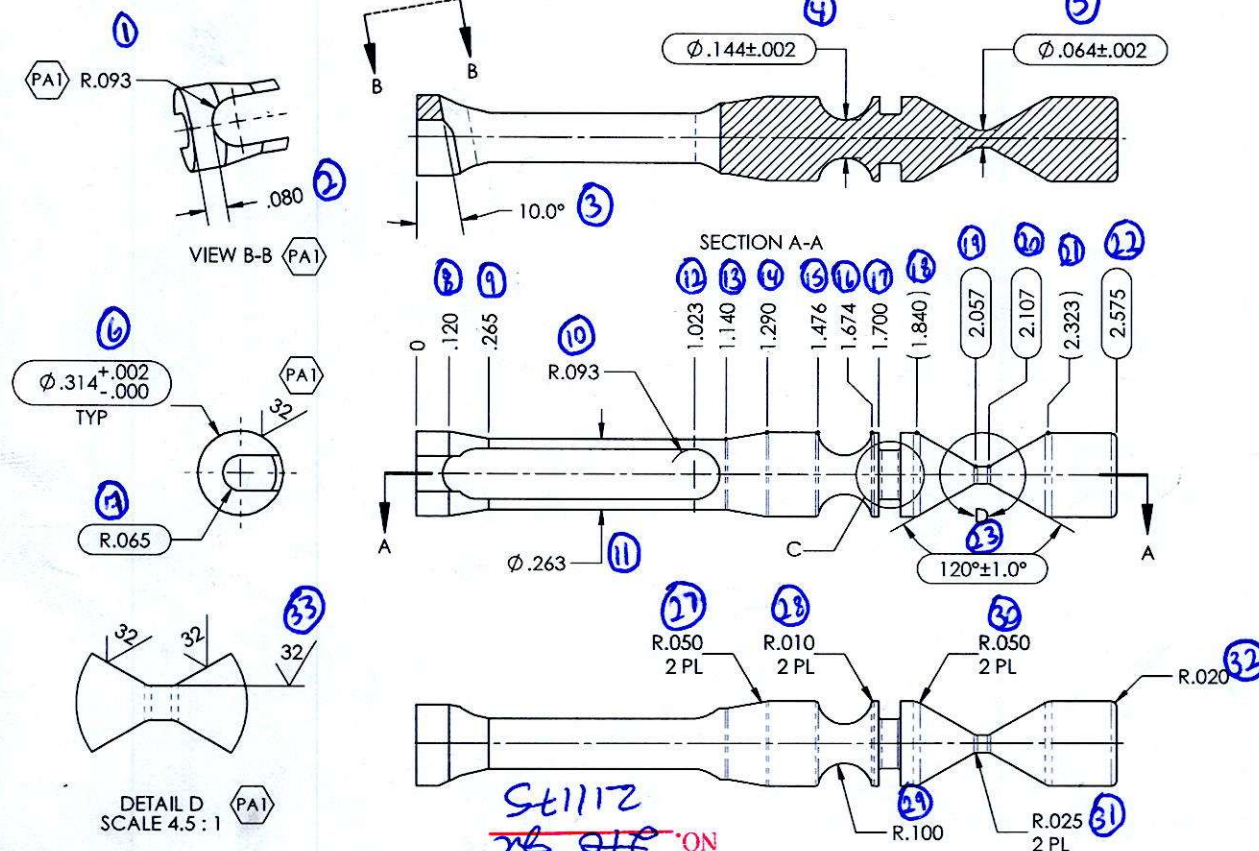
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE	04-28-2014	P. BRAVO
A	INCORPORATED ECN 05014	07-13-2015	P. BRAVO



650.7810



DETAIL C
SCALE 5:1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 370 94
211175

		1.	650.7810	PULL ROD		
	FINO	NO.	PART NO.	DESCRIPTION	MATL	SPEC
QTY	"		PARTS LIST			
NEXT ASSY (S)	ORIGINAL DATE 04-28-2014 DRAWN BY N CAP P BRAVO		 3030 ENTERPRISE CT SUITE A VISTA, CA. 92081 (760)-724-5300 APICAL INDUSTRIES, INC. dco DART Aerospace			
650.5300	DRAWING APPROVAL P BRAVO 04-28-2014 CONTRACT NO.		PULL ROD			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .010 3 PLACE DECIMALS ± .005 ANGLES ± .5°			SITE CAGE CODE DWG. NO. REV. PA SCALE NONE 650.7800 1 OF 1 SHEET NONE SHEET 1 OF 1			

DART AEROSPACE LTD		Work Order: 211175
Description: PULL ROD		Part Number: 650, 7810
Inspection Dwg: 650, 7800 Rev: PA1		Page 1 of 1

INSPECTION SHEET

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1	R 0,093	± 0,005	0,093	✓		MJP-04	vern
2	0,080	± 0,005	0,081	✓		↓	↓
3	10°	± 0,5°	10°	✓		↓	↓
4	0,144	± 0,002	0,146	✓		MJP-04	vern
5	0,064	± 0,002	0,063	✓		↓	↓
6	0,314	± 0,003	0,314	✓		↓	↓
7	R 0,065	± 0,005	0,063	✓		MJP-04	vern
8	0,120	± 0,005	0,121	✓		MJP-04	vern
9	0,265	± 0,005	0,266	✓		...	...
10	R 0,093	± 0,005	0,093	✓		...	...
11	0,263	± 0,005	0,267	✓		MJP-04	vern
12	1,023	± 0,005	1,022	✓			
13	1,140	± 0,005	1,140	✓		MJP-04	vern
14	1,290	± 0,005	1,290	✓			
15	1,476	± 0,005	1,476	✓			
16	1,674	± 0,005	1,674	✓			
17	1,700	± 0,005	1,700	✓			
18	1,840	± 0,005	1,840	✓			
19	2,057	± 0,005	2,057	✓			
20	2,107	± 0,005	2,107	✓			
21	2,323	± 0,005	2,323	✓			
22	2,575	± 0,005	2,576	✓			
23	120°	± 1,0°	120°				
24	0,080	± 0,005	0,080	✗			
25	0,183	± 0,002	0,183	✓			
26	R 0,010	± 0,005	0,010	✓			
27	R 0,050	± 0,005	0,050	✓			
28	R 0,010	± 0,005	0,010	✓			
29	R 0,100	± 0,005	0,100	✓			
30	R 0,050	± 0,005	0,050	✓			
31	R 0,025	± 0,005	0,025	✓			
32	R 0,020	± 0,005	0,020	✓			

ACCEPTED PER DEVIATION

DAS 82 9-89

DAS 82 9-89

Measured by: 33	Checked by: <i>[Signature]</i>	QC Inspector:
Date: 20/08/21	Date: 20/08/21	Date: SEP 01 2020

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046954



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046954

PO Date: 8/25/20

Due Date: 9/2/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	212077	650.9610	650.9600 REV-PB2	Electric Valve Body -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed X6	-	9/2/20	6 pcs	0 pcs	6 pcs	\$0.35/pcs	\$2.10
									AUG 31 2020			
2	210876	651.0101	651.0100 REV.PE2	Angled Gauge Adapter -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 316 stainless steel -Certificate of Conformity is required	Firmed X3	-	9/2/20	3 pcs	0 pcs	3 pcs	\$0.35/pcs	\$1.05
									AUG 31 2020			
3	210662	650.7712	650.7700 REV.PF1	Mechanical Cap -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed X3	-	9/2/20	3 pcs	0 pcs	3 pcs	\$0.35/pcs	\$1.05
									AUG 31 2020			
4	211175	650.7810	650.7800 REV.PA1	Pull Rod -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed X3	-	9/2/20	3 pcs	0 pcs	3 pcs	\$0.35/pcs	\$1.05
									AUG 31 2020			

DAS
82
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046954



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	212002	654.6411	654.6400 REV-PR2	Plug Fitting -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed XS	-	9/2/20	5 pcs	0 pcs	5 pcs	\$0.35/pcs	\$1.75
											AUG 31 2020	
6	212001	654.6412	654.6400 REV-PR2	Fill Piston Fitting -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed XS	-	9/2/20	5 pcs	0 pcs	5 pcs	\$0.35/pcs	\$1.75
											AUG 31 2020	
7	211954	647.2511	647.2500 Rev A	Nut : Various STC's Issue P/O: _____ Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required	Firmed X36	-	9/2/20	36 pcs	0 pcs	36 pcs	\$2.45/pcs	\$88.20
											AUG 31 2020	
8	211953	647.2510	647.2500 Rev A	Sleeve : Various STC's Issue P/O: _____ Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required	Firmed X36	-	9/2/20	36 pcs	0 pcs	36 pcs	\$0.88/pcs	\$31.68
											AUG 31 2020	
Grand Total:											\$128.63	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

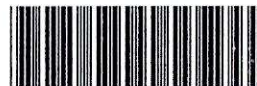
A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/28/20 4:16 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance



0 3 0 5 5 4 - 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip

030554 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

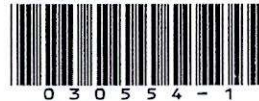
Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
28-Aug-2020		Ian Wilson		POHB046954				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	A venir/ Back Order
1	650.9610 Rev.	650.9610 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST PASSIVATE IAW QQ-P-35C MATERIAL TYPE: 303 STAINLESS STEEL	PASSIVATION CH	6	6	0	0	0
2	651.0101 Rev.	651.0101 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST PASSIVATE IAW QQ-P-35C, TYPE II MATERIAL TYPE: 316 STAINLESS STEEL	PASSIVATION CH	3	3	0	0	0
3	650.7712 Rev.	650.7712 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] PASSIVATE IAW QQ-P-35C, TYPE II MATERIAL TYPE: 303 STAINLESS STEEL	PASSIVATION CH	3	3	0	0	0
4	650.7810 Rev.	650.7810 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] PASSIVATE IAW QQ-P-35C, TYPE II MATERIAL TYPE: 303 STAINLESS STEEL	PASSIVATION CH	3	3	0	0	0
5	654.6411 Rev.	654.6411 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] PASSIVATE IAW QQ-P-35C, TYPE II MATERIAL TYPE: 303 STAINLESS STEEL	PASSIVATION CH	5	5	0	0	0
6	654.6412 Rev.	654.6412 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] PASSIVATE IAW QC-P35C, TYPE II MATERIAL TYPE 303 STAINLESS STEEL	PASSIVATION CH	5	5	0	0	0
7	647.2511 Rev.	647.2511 01 -PASSIVATION DICHROMATE [PASSIVATION DICHROMATE] PASSIVATE AS PER MIL-S-5002 TYPE 6	PASSIVATION CH	36	36	0	0	0
8	647.2510 Rev.	647.2510 01 -PASSIVATION DICHROMATE [PASSIVATION DICHROMATE] PASSIVATE AS PER MIL-S-5002 TYPE 6	PASSIVATION CH	36	36	0	0	0

 DAS
 82
 9-89

RECEIVED

AUG 28 2020

DART AEROSPACE LTD.


Certificat de Conformité / Certificate of Compliance


2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip
030554 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
28-Aug-2020		Ian Wilson		POHB046954				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities		À venir / Back Order
						Qté NC/ NC Qty	Qté Scrap/	
RECEIVED AUG 28 2020 DART AEROSPACE LTD.								

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

Management Systems
Certified by
LRQA
ISO 9001 / SGI 6000360
ISO 14001 / SGI 1870678

184581
DART

32438
ACEROS INOXIDABLES
55942
OLARRA



3

Certificate type - APZ Nach Certificado tipo		EN 10204/3.1		Certificate n° - Prüf-Nr Certificado n°		379422		Date - Datum - Fecha 20 - 02 - 2019		
Our order N° Werks - Nr N° de Referencia		677878		Heat Schmelze Colada		469668		Your order N° Bestell - Nr Pedido N°		
Steel Grade Werkstoff Calidad		AISI-303		DAS 82 9-89		DEC 20 2019		According to Entsprechend Corresponde		
Shape and Size - Gegenstand Perfil y dimensión ROUND 3/8"		Tolerance - Toleranz Tolerancia ASTM A 484 /TB.7		Bundles Bunde Bultos		2		Bars Stäbe Barras		
Weight Gewicht Peso		2571 Lbs		ASTM A 582 / A 582M-12.						
Requirements - Anforderungen - Exigencias										
QQ-S 784B-70: AMD2 COND.A. SAE AMS 5640U-07: TYPE I. EN 10.088-3:2014. 1.4305. MECAMAX - PLUS										
Melting process / Erschmelzungsart / Proceso de Fusión E.A.F. / A.O.D.				Heat treatment / Wärmebehandlung / Tratamiento térmico 1050C 4H/Std WATER/WASSER/AGUA						
Solution annealed/Abgeschreckt/Hipertempe-Cold drawn/Gezogen/Estirado-Polished/Poliert/Pulido-										
Test results - Ergebnis der Prüfungen - Resultados de los ensayos										
Dimension of Specimen Abmessungen des Probestabes Medida de las probetas		Rp0.2% KSI	Rp 1% KSI	Rm KSI	A %L 5D	A %L 4D	Z %	Hardness Härte HBw	Impact test / Kerschschlag / Resiliencia ISO V ft. lb	
RD. 9,53 mm.		Min.								
		Max.						262		
Temperature °C 20	Spec. N° Probe Nr. Pro N°	1	98	113	116	30	42	255		
C	Si	Mn	P	S	Cr	Mo	Ni	Cu	N	Co
Min.				0,150	17,00		8,00			
Max.	0,150	1,00	2,00	0,200	19,00		10,00	0,70	0,1000	
	0,046	0,42	1,78	0,039	0,330	17,91	0,31	8,36	0,51	0,0365
Visual and dimensional inspection Besichtigung und Ausmessung Control visual y dimensional		Radioactivity inspection Radioaktivitätskontrolle Control de Radioactividad		Antimixing test Spektroak Verwechslungspr Antimezcla		Grain Size Korngrösse Tamaño de grano				
Remarks - Bemerkungen - Observaciones										
Free From Mercury contamination/Quecksilberfreiheit. No weld repair.										
EDV / EDP Acc. EN 10.204 Marian Tejedo Quality Mng. Works inspector Der Werkssachverständige Inspector de fábrica										
We hereby certify that material described herein complies with the requirements agreed on the order										

227007

Firmado digitalmente por / Signed digitally by:
ACEROS INOXIDABLES OLARRA SA - CIE A48623548



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045395**



Supplier: ACI001-VC
Acier Ouellette Inc.
935 Boul. Du Havre
Valleyfield
QC
J6S 5L1 Canada
Phone: 800 667 4248
Fax: 450 377 5696

Attention: Langevin, Melanie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045395

PO Date: 12/13/19

Due Date: 12/20/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments: quote no. sou0229385

DEC 13 2019

Items													
Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		MT-HRS-B-2.500X3.500			Hot Rolled Steel Bar 2.500W X 3.500H : MATERIAL: HOT ROLLED STEEL BAR ASTM A36 OR ASTM A1011 OR 44W OR ASTM A1018	Firmed -		1/10/20	6 ft	0 ft	6 ft	\$80.00/ft	\$480.00
									6 ft			DAS 82 9-89	JAN 09 2020
2		M304R0.250			304 SS Round bar .250 : MATERIAL: AISI 304/316 SS ROUND BAR AS PER ASTM A276 NOTE: AISI 303 NOT ACCEPTABLE receive ft	Firmed -		12/20/19	12 ft	0 ft	12 ft	\$0.5275/ft	\$6.33
									13.75 ft (1 pc)			DAS 82 9-89	DEC 20 2019
3		M304R0.375			304 Round Bar 0.375 : MATERIAL: AISI 304/316 SS ROUND BAR AS PER ASTM A276 NOTE: AISI 303 NOT ACCEPTABLE receive ft	Firmed -		12/20/19	24 ft	0 ft	24 ft	\$1.1504/ft	\$27.61
									24 ft (2 pc)			DAS 82 9-89	DEC 20 2019
4		M303R0.375			303 Round Bar 0.375" : MATERIAL: AISI 303 SS ROUND BAR AS PER ASTM A582 NOTE: 304/316 NOT ACCEPTABLE receive ft	Firmed -		12/20/19	36 ft	0 ft	36 ft	\$1.357222/ft	\$48.86
									37.5 ft (3 pc)			DAS 82 9-89	DEC 20 2019
5		M303R0.625			303 Round Bar 0.625" : MATERIAL: AISI 303 SS ROUND BAR AS PER ASTM A582 NOTE: 304/316 NOT ACCEPTABLE receive ft	Firmed -		12/20/19	24 ft	0 ft	24 ft	\$3.7645833/ft	\$90.35
									24 ft (2 pc)			DAS 82 9-89	DEC 20 2019
6		M303R0.750	648.1400		303 Round Bar 0.750 : MATERIAL: AISI 303 SS ROUND BAR AS PER ASTM A582 NOTE: 304/316 NOT ACCEPTABLE receive ft	Firmed -		12/20/19	72 ft	0 ft	72 ft	\$5.4965277/ft	\$395.75
									73.5 ft (4 pc)			DAS 82 9-89	DEC 20 2019

Plex 12/13/19 1:57 PM Dart,Lavoie,Chantal

Plex 12/13/19 1:57 PM Dart.Lavoie.Chantal

**ACIER OUELLETTE INC.**

935, Boul. du H vre
Salaberry de Valleyfield (Qu bec) J6S 5L1
T l.: 450-377-4248 M l: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 M l: 514-336-4246 Ext.: 866-456-4242

DELIVERY - CLIENT

Copy

CO00184581

Billed to

DART AEROSPACE LTD
1270 , ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to

1270 , ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Att : CHANTAL

Delivery Route 5**Customer N ****Date****Delivery date****Your order N ****Processed by****Salesman****Carrier****Credit Terme**

CLI0001056

2019/12/13

2019/12/18

POHB045395

Josianne Bourdon

JOSIANNE BOURDON

OUELLETTE VALLEYFIELD

Net 30 Days

Instruction F-M

Product Description	Weight	Qty	UM	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 ROUND SS 304 1/4 (R) RSS-14 5742 DAS 1 X 12' R/L 82 POHB045395 LINE 2 9-89 HEAT: FF-6524 DEC 2 0 2019	2.00	12.00	PI_\$CLB		1x 12'10"						
2 ROUND SS 304 3/8 (R) RSS-38 5768 2 X 12' R/L DAS POHB045395 LINE 3 22 HEAT: 51089 DEC 2 0 2019	9.02	24.00	PI_\$CLB		2x 12'1"						
3 ROUND SS 303 3/8 (R) RSS-38303 5765 3 X 12' R/L DAS POHB045395 LINE 4 82 HEAT: 469668 9-89 AC32438-CF-16/12 DEC 2 0 2019	13.54	36.00	PI_\$CLB		3x 12'6"						
4 ROUND SS 303 5/8 NS RSS-58303 8749 2 X 12' R/L DAS POHB045395 LINE 5 82 HEAT: C67B 9-89 AC32438-CF-16/12 DEC 2 0 2019	25.03	24.00	PI_\$CLB		2x 12'1"						
5 ROUND SS 303 3/4 (R) RSS-34303 5761 6 X 12' R/L DAS POHB045395 LINE 6 82 HEAT: 461574 9-89 DEC 2 0 2019	108.14	72.00	PI_\$CLB		1x12' 2x12'1" 1x12'5" 2x12'6"						

RECEIVED

DEC 19 2019

DART AEROSPACE LTD.

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M303R 0.375
 DATE: DEC 20 2019

PO / BATCH NO.: POHBOY 5395
5243101

MATERIAL CERT REC'D: YES
 QUANTITY RECEIVED: 37.5FT
 QUANTITY INSPECTED: 37.5FT
 QUANTITY REJECTED:

THICKNESS ORDERED: φ .375
 THICKNESS RECEIVED: φ .375
 SHEET SIZE ORDERED:
 SHEET SIZE RECEIVED:

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	☒ N	
CORRECT FINISH	☒ Y	N	
CORROSION	Y	☒ N	
CORRECT GRAIN DIRECTION	☒ Y	N	
CORRECT MATERIAL PER M-DRAWING	☒ Y	N	ASTM A582
CORRECT THICKNESS	☒ Y	N	
PHOTO REQUIRED	Y	☒ N	
CORRECT REF # TO LINK CERT	☒ Y	N	HIT 469668 ✓
CORRECT MATERIAL IDENTIFICATION	☒ Y	N	
CORRECT M# ON THE MATERIAL	☒ Y	N	✗
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>82</u> 9-89		SIGNED OFF BY: _____	
DATE: <u>DEC 20 2019</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in